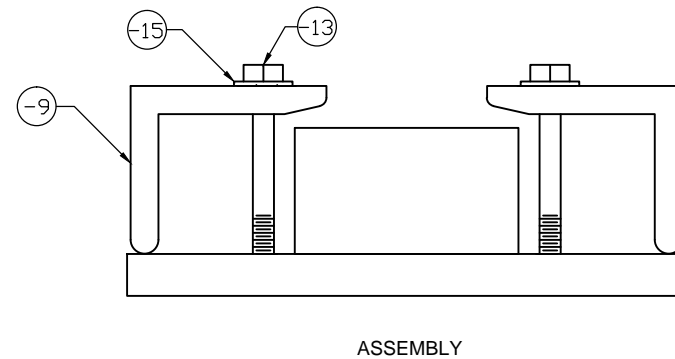
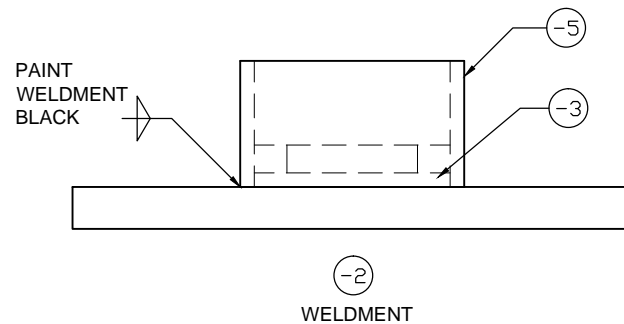
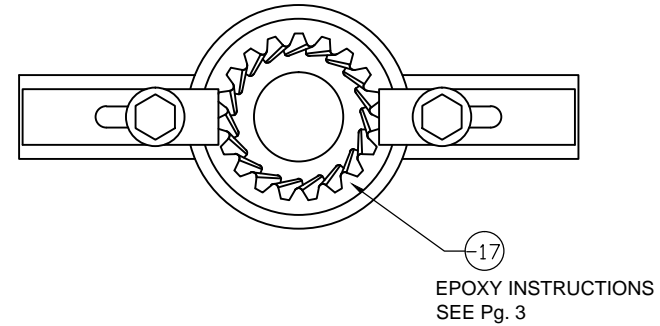
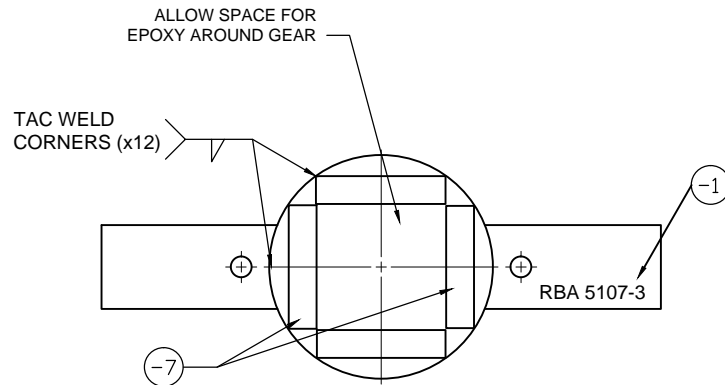


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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	CORRECTED P/N -1 DIM'S, ADDED MISSING DIM'S, ADDED ASSY VIEW & WELDMENT VIEWS, CH'D TITLEBLOCK & REVISION BLOCK.	9/18/09	-	-

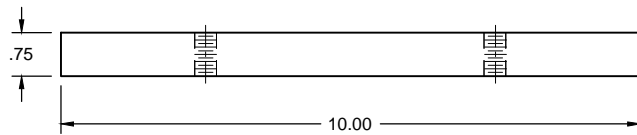
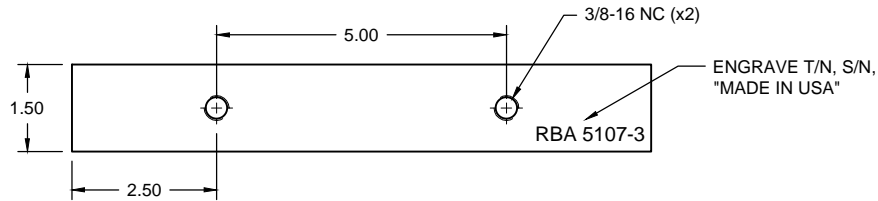


ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
			-1	1	BASE	1018	3/4 x 1-1/2 x 10	2
			-2	1	WELDMENT		-1, -3, -5, -7, -11	1
1			-3		BOTTOM	1018	Ø3-1/2 x 1/4	2
1			-5		RING	DOM	Ø4 x 1/4 WALL x 2-1/4	2
4			-7		STIFFENER	1018 FLAT BAR	1/2 x 1/2 x 2-1/4	1
			-9	2	CLAMP	HR	1/2 x 3 x 3-1/2	2
	B/O		-13	2	HEX HEAD CAP SCREW	GR. 5, PLATED	3/8-16 UNC x 3-1/2	1
	B/O		-15	2	WASHER	PLATED STEEL	Ø3/8	1
	B/O		-17	1	EPOXY	DEVCON FLAXANE 94	1/2 CAN OF MIXED COMPOUND APPLIED #15250	1
	B/O		-19	1	RELEASE AGENT	DEVCON	APPLIED #19600	NS

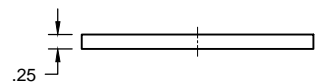
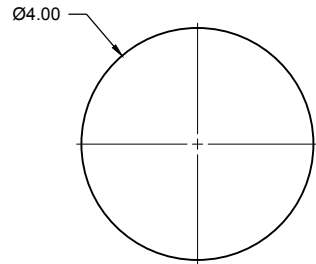
RED BARN MACHINE	
TITLE HOLDING FIXTURE	
DWG NO. RBA5107-3	REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	DRAWN BY: COLE APPROVED HEAT TREAT FINISH SPEC USED ON MODEL
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 2-1-02
SHEET 1 of 3	

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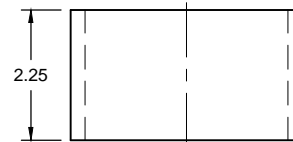
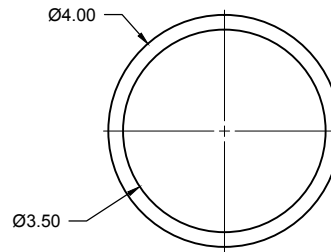
REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
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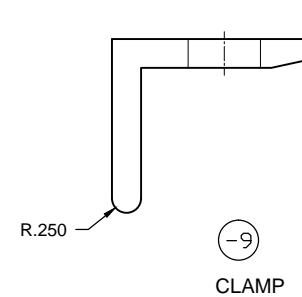
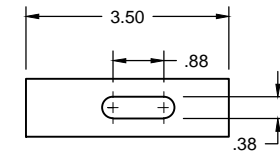
(-1)
BASE




(-3)
BOTTOM



(-5)
RING



(-9)
CLAMP

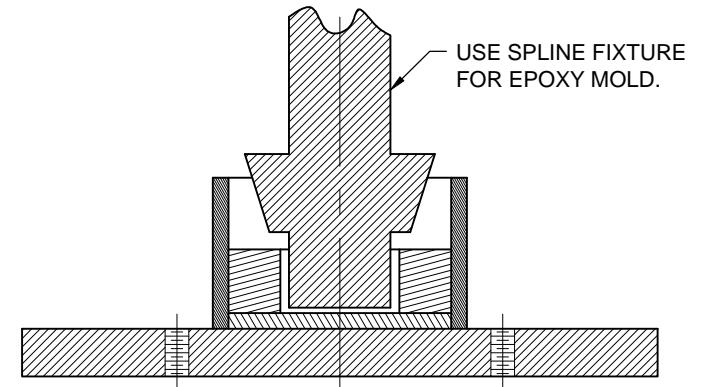
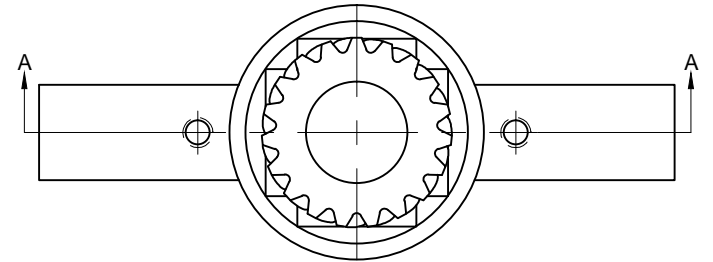
 RED BARN MACHINE	
TITLE HOLDING FIXTURE	
DWG NO. RBA5107-1 thru -9	REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 X ± .1	DRAWN BY: COLE APPROVED HEAT TREAT FINISH SPEC USED ON MODEL
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 9-18-09
SHEET 2 of 3	

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
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POURING OF EPOXY INTO GEAR POTS

1. BE SURE THAT THE SMALL BLOCKS OF STEEL HAVE BEEN WELDED INTO THE CAVITY, THIS WILL HELP FILL THE CAVITY AND STOP THE ROTATION OF THE GEAR. BE CAREFUL TO ALLOW SPACE FOR THE EPOXY AROUND THE GEAR.
2. THOROUGHLY BEAD BLAST THE INSIDE OF THE CAVITY AND OUTSIDE OF THE HOUSING.
3. PAINT THE OUTSIDE OF THE POT ASSEMBLY WITH FLAT BLACK PAINT.
4. LEVEL THE TOP LIP OF THE CAVITY. IT SHOULD HAVE ALREADY BEEN MACHINED.
5. WET THE GEARED SPLINE WITH DEVCON BRAND RELEASE AGENT ONLY.
6. MIX FLEXANE 94 LIQUID AND THE CATALYST WITH A DRILL MOTOR AND A MIXING BLADE FOR A FULL 2 MINUTES. APPROXIMATELY A HALF CAN OF MIXED COMPOUND IS NEEDED.
7. POUR ENOUGH FLEXANE 94 INTO POT TO FILL ABOUT HALF WAY UP THE SIDE.
8. CAREFULLY PLACE THE GEARED SPLINE INTO THE MIDDLE OF THE POT.
9. CAREFULLY FILL THE POT TO THE TOP OR SLIGHTLY ABOVE, DO NOT GET MATERIAL ON TOP OF THE METAL EDGE OR DOWN THE SIDES OF THE POT.
10. USE A HEAT GUN TO BURST ALL THE BUBBLES THAT COME TO THE TOP OF THE POURED MIXTURE.
11. AFTER THE FLEXANE 94 HAS SETUP ABOUT 10 MINUTES CAREFULLY BREAK THE GEARED SPLINE LOOSE.
12. LEAVE THE GEARED SPLINE IN PLACE UNTIL THE FLEXANE HAS SET UP COMPLETELY, ABOUT 1 HOUR.
13. PREPARE EXTRA POTS AND POUR WITH EXCESS MATERIAL. DO NOT MAKE PARTIAL POURS OF FLEXANE 94 INTO POTS.



-2 WELDMENT
SECTION A-A

 RED BARN MACHINE	
TITLE HOLDING FIXTURE	
DWG NO. RBA5107-3	REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	DRAWN BY: COLE APPROVED HEAT TREAT FINISH SPEC USED ON MODEL
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 9-18-09 SHEET 3 of 3

